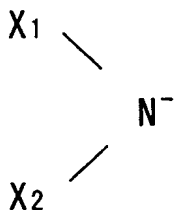


WHAT IS CLAIMED IS:

1. A flame-retardant seamless belt composed of a thermoplastic composition containing a polyester thermoplastic elastomer as a main component thereof; at not less than 15 wt% nor more than 40 wt% of melamine cyanurate, serving as a flame-retardant additive, for a whole weight of said thermoplastic composition; and not less than 0.01 parts by weight nor more than three parts by weight of an anion-containing salt, shown by a chemical formula 1 shown below, for 100 parts by weight of an entire polymer component,

wherein said thermoplastic composition has a volume resistivity of not less than $1.0 \times 10^6 \Omega \cdot \text{cm}$ nor more than $1.0 \times 10^{12} \Omega \cdot \text{cm}$.

Chemical Formula 1



where X_1 and X_2 denote functional group, containing C, -F, and $-\text{SO}_2-$, whose number of carbon atoms is one to eight.

2. The flame-retardant seamless belt according to claim 1, wherein said X_1- of said chemical formula 1 is $\text{C}_{n_1}\text{H}_{m_1}\text{F}_{(2n_1-m_1+1)}-\text{SO}_2-$, and said X_2- of said chemical formula 1 is $\text{C}_{n_2}\text{H}_{m_2}\text{F}_{(2n_2-m_2+1)}-\text{SO}_2-$ (n_1 and n_2 are integers not less than 1, and m_1 and m_2 are integers not less than 0).

3. The flame-retardant seamless belt according to claim 1,

wherein a cation making a pair with said anion, shown by said chemical formula 1, which constitutes said salt is a cation of any one of alkali metals, group 2A metals, transition metals, and amphoteric metals.

5 4. The flame-retardant seamless belt according to claim 3, wherein a metal constituting said cation is lithium.

5. The flame-retardant seamless belt according to claim 1, wherein said anion-containing salt is lithium-bis (trifluoromethanesulfonyl) imide.

10 6. The flame-retardant seamless belt according to claim 1, wherein said anion-containing salt shown by said chemical formula 1 is added to said entire polymer component without intermediary of a medium consisting of a low-molecular-weight polyether-containing compound or a low-molecular-weight polar
15 compound whose molecular weight is not more than 10000.

7. The flame-retardant seamless belt according to claim 1, wherein supposing that a volume resistivity of said flame-retardant seamless belt measured at a low temperature of 10°C and a low humidity of 15% is R_{LL} and that a volume resistivity thereof measured at a
20 high temperature of 32.5°C and a high humidity of 90% is R_{HH} , the volume resistivity R_{LL} and the volume resistivity R_{HH} satisfy an equation of $\log_{10}R_{LL} - \log_{10}R_{HH} \leq 2.5$.

8. The flame-retardant seamless belt according to claim 1, having at least one coating layer on a peripheral surface thereof.

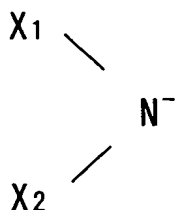
25 9. A method of manufacturing a flame-retardant seamless belt

comprising the steps of:

fusing and kneading, by an extruder, a conductive master batch containing a polyester thermoplastic elastomer and not less than one wt% nor more than 20 wt% of an anion-containing salt, shown below by a chemical formula 1, added to said polyester thermoplastic elastomer; a flame-retardant additive; and a thermoplastic composition containing said polyester thermoplastic elastomer as a main component thereof to form a material for said flame-retardant seamless belt; and

extruding said material from an annular die and molding said material into a shape of a belt by using a sizing die.

Chemical Formula 1



Where X_1 and X_2 denote functional group which contains C, -F, and -SO₂- and in which the number of carbon atoms is one to eight.

10. The method according to claim 9, wherein said flame-retardant additive and said thermoplastic composition containing said polyester thermoplastic elastomer as said main component thereof are kneaded and supplied to said extruder as a flame-retardant master batch; and said mixture of said conductive master batch and said flame-retardant master batch are extruded vertically from said annular die.

11. An image-forming apparatus having said flame-retardant seamless belt according to claim 1.